

Date: Wednesday, 12/7/2005 8:26:08 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE SIDE LH (206 HI-SLOPE)
Job Number : 25140	
Estimate Number : 11000	
P.O. Number : N/A	Part Number : D26021
This Issue : 12/7/2005 S.O. No. : N/A	Drawing Number : D2602 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : N/A	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 1/10/2006 Qty: 10 Um: Each
Checked & Approved By : SEE COMMENT BELOW	
Comment : Est. D 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-2	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 1.4146 sf(s)/Unit Total: 14.1456 sf(s)
 2024-T3 .040 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040) Batch M19059

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut Blank per template DT8243

J.L 05.12.16 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA145 and Dwg D2602
 Stack of 10
 Identify as D2602-1

J.L 05.12.16 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 05.12.16 10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

E 05/12/16 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 22 Date: 06/10/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 8:26:08 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 25140

Part Number: D26021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

SD 06/01/16 10

SAD 1/18/12/05 10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-01-16 10

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-01-19 10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

206-01-19 10

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA.

FF 06-01-24 10

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 06/01/24 10

LD 06/01/24

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25140
Description: Console Side LH/RH	Part Number:	D2602-1/-2
Inspection Dwg: D2602 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

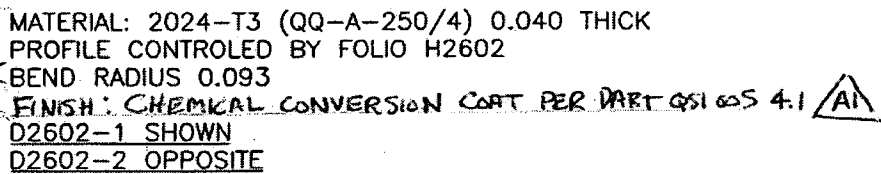
[illegible]

Measured by:	JL	Audited by:	me	Prototype Approval:	N/A
Date:	05-12-16	Date:	05/12/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
<i>W</i>	<i>BW</i>		
CHECKED	APPROVED	DRAWING NO.	REV. A
<i>KE</i>	<i>S</i>	D2602	SHEET 1 OF 1
DATE	TITLE		SCALE
97.10.22	CONSOLE SIDE		1:4
A	97.10.22	D2602 WAS D206-547-21 / -22	
AI	<i>W</i>	02.06.04	ADD FINISH



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